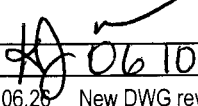


Date: Monday, 10/30/2006 4:15:16 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number :	29231	Part Number :	D29322
Estimate Number :	10832	Drawing Number :	D2932 REV B
P.O. Number :	NIA	Project Number :	N/A
This Issue :	10/30/2006	Drawing Revision :	B
Prsht Rev. :	NC	Material :	NIA
First Issue :	NIA	Due Date :	11/30/2006
Previous Run :	28859	Qty:	13
Written By :			Um: Each
Checked & Approved By :	 061031		
Comment :	Est: B 00.06.26 New DWG rev (mpp 2069) EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88

Grain Along Long 7.88 Length

Batch No: B25348

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

SD/SL 06/11/07

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SD 06.11.19

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SD/SL 06/11/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 18 Date: 06/11/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/30/2006 4:15:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 29231

Part Number: D29322

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06/11/22

12

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Y

06/11/24

X 12

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M102391

P.C

Y

06/11/27

X 12

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/11/27

(12)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *st427*

06/11/27

(12)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

06/11/28

Job Completion



C Loc 11/1/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 29231
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.115	.118	.119	.118		
B	0.100	0.140		.115	.118	.119	.118		
C	0.100	0.140		.114	.120	.121	.118		
D	0.210	0.230		.220	.220	.220	.226		
E	1.245	1.255		1.256	1.256	1.249	1.256		
F	1.245	1.255		1.249	1.250	1.250	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.502	2.501	2.502	2.502		
K	0.257	0.262	DT8683	.257	.258	.258	.258		
L	0.312	0.317	DT8686	.313	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.113	.121	.120	.120		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.499	.500	.500	.499		
Q	3.715	3.725		3.719	3.720	3.720	3.726		
R	2.470	2.510		2.492	2.493	2.492	2.493		
S	0.240	0.270		.250	.251	.250	.251		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.317	.319	.319	.317		
X	1.125	1.145		1.133	1.133	1.132	1.134		
Y	1.565	1.585		1.572	1.572	1.572	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SA
Date: 06.11.22

Audited by: [Signature]
Date: 06/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

DART AEROSPACE LTD	Work Order: 29231
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116	.117	.119	.119		
B	0.100	0.140		.118	.118	.117	.118		
C	0.100	0.140		.120	.120	.119	.118		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.258	1.258	1.258	1.258		
F	1.245	1.255		1.248	1.248	1.256	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.502	2.501	2.502	2.502		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.121	.120	.120	.120		
O	0.540	0.560		.550	.551	.550	.550		
P	0.490	0.510		.508	.498	.499	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.250	.257	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.315	.315	.315	.315		
X	1.125	1.145		1.133	1.133	1.132	1.133		
Y	1.565	1.585		1.573	1.573	1.572	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SA
Date: 06.11.06.

Audited by: gml
Date: 06/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

DART AEROSPACE LTD	Work Order: 29231
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.118	.116	.118	.118		
B	0.100	0.140		.118	.118	.119	.119		
C	0.100	0.140		.120	.120	.121	.121		
D	0.210	0.230		.220	.218	.218	.219		
E	1.245	1.255		1.256	1.249	1.250	1.250		
F	1.245	1.255		1.245	1.250	1.250	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.500	2.499		
K	0.257	0.262	DT8683-	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.120	.119	.119	.118		
O	0.540	0.560		.550	.550	.550	.549		
P	0.490	0.510		.500	.499	.499	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.719		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.250	.248	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.319	.319	.319	.319		
X	1.125	1.145		1.133	1.133	1.133	1.131		
Y	1.565	1.585		1.572	1.572	1.572	1.571		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SN	3.L
Date: 06.11.06	06/11/07

Audited by: gml
Date: 06/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

